

Date: Wednesday, 06/09/2006 11:05:11 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28420
 Estimate Number : 12495
 P.O. Number : N/A
 This Issue : 06/09/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 28358
 Written By : EE
 Checked & Approved By : _____
 Comment : Est Rev:A New Issue 06-07-26 JLM

Drawing Name : GPS RECEIVER HOUSING
 Part Number : D35149
 Drawing Number : UNDER REVIEW EE 06-09-05
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 13/09/2006 Qty: 1 EE Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.1969 sf(s)/Unit Total: 0.1969 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: MM380

mm 06 09 07

2.0 WATER JET FLOW WATER JET



See Pro
At Step 50

Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: Pre1

Prog Rev: Pre1

Ensure Grain Direction is correct**

2-Deburr if necessary

mm 06 09 08 ①
06 09 07

06 09 08 ①

06 09 07 ①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



06 09 08 ①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mm

06 09 07

①

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06 09 08 ①

06 09 07 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 01/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28420

Part Number: D35149

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form Juggle as per Dwg D3514

SP 06/09/07

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EC 06.09.14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 06-09-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EC 06.09.14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Per eng. use only.

EC 06.09.14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

EC 06.09.14

Job Completion



W 06.09.20

Eng Approval

CB 07.03.08

PART NOT MARKED AS PROTOTYPE. PART WENT TO HAI.
PART NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-09-13	5.0	As per part As per Dwg. No joggle required for A-9 Perm. Change					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-09-07	5.0	30° bend in opposite direction. Human error.		Scrap & destroy & replace.	 06-09-08	 06-09-08	 06-09-08	 06-09-07

NOTE: Date & initial all entries

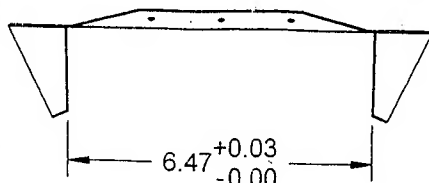
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SHEET 7 OF 7 SCALE 1:2

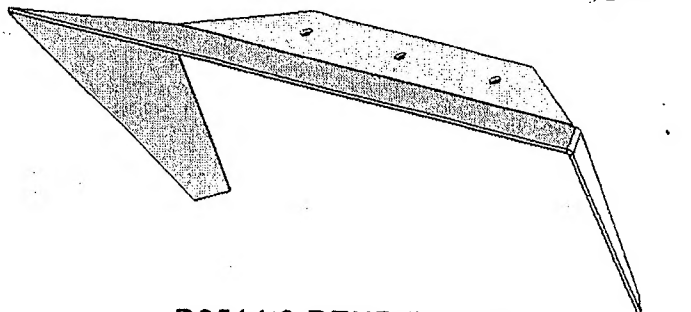
UNDER REVIEW

06.08.22 CB

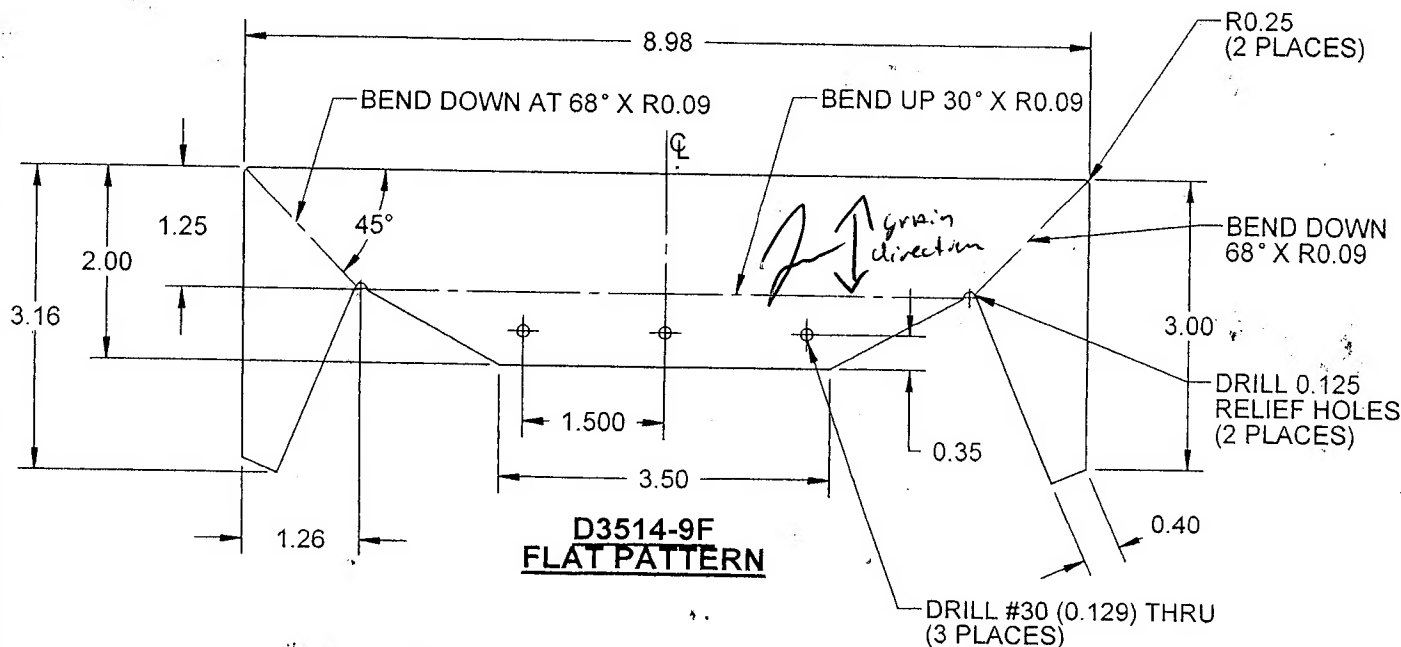
prototype



FRONT VIEW
SCALE 1:4



D3514-9 BEND DETAIL



D3514-9F
FLAT PATTERN

D3514-9 HOOD

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT ϕ

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DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

Corus Aluminium N.V.
A. Stodetlaan 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMBER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC), AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0.04"
ARTIKEL NR.:

ROL- NUMMER	GEUT- NUMMER	CHEMISCHE ANALYSE (%)							
		SI	FE	CU	MN	MG	CR	TI	ZN
		MIN	0,40	0,15	0,15	0,8	0,04		
		MAX	0,8	0,40	0,15	1,2	0,35	0,15	0,25
001	7124901		0,67	0,22	0,09	1,1	0,16	0,02	0,01
002	7124901		0,67	0,22	0,09	1,1	0,16	0,02	0,01
ANDERE : ELK				MIN		0,05 MAX			
TOTAAL :				MIN		0,15 MAX			

TEST- NUMMER		MECHANISCHE EIGENSCHAPPEN			
		1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI			
		/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM			
		RM	RP02	A	
		KSI	KSI	%	
	MIN	42	35	10	
	MAX				
001	/A	47	39	16	
001	/M	47	39	15	
001	/V	47	39	16	
002	/A	47	39	16	
002	/M	48	40	16	
002	/V	48	39	16	

COPPER AND BRASS SALES

SOLD TO: C&BDATE: 12/16 QTY. 20CUSTOMER PO: 0000624SHIPPER NO: 4V3428BY: 8

Corus Aluminium Rolled Products - Corus Aluminium Extrusions